

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026452**Date Inspected:** 03-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

East Line

This QA randomly observed ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1010. The joint being welded is a 20mm plate insert at the "A" deck to close a man way deck penetration hole. This work was located at 8E-PP70.5-E5 NE and was performed in the overhead position from the bottom of the "A" deck plate.

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters. Welding parameters were recorded as (A=122).

This QA randomly observed ABF/JV qualified welder Fred Kaddu #2188 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. This was a Complete Joint Penetration (CJP) weld on a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at E3-PP100-L#1&3 and was performed in the overhead position from the bottom of the "A" deck plate.

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters.

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Welding parameters were recorded as (A=125).

This QA performed observation at random intervals of approved ABF welding personnel performing fit-up and Shielded Metal Arc Welding (SMAW) of temporary attachments at the "A" deck plates and "D" bottom plates of 12E/13E and 12W/13W segment splices.

At these temporary attachment locations this QA has observed arc strikes outside the weld joint at various locations on both the Lift 12 (non SPCM material) and the Lift 13 (SPCM material) sides of these segment splices.

At this time, this QA has not been presented with approved Welding Procedure Specification's (WPS') for the welding of these temporary attachments.

Approximately:

12:15 this QA observed QC Bernard Docena perform Magnetic Particle (MT) of the back gouged welds at panel point E3-PP100-L#1&3 location. Mr. Docena recorded no rejectable indications at this time.

13:00 ABF field supervisors halted all "A" deck welding processes due to inclement weather (rain).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
